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D3914-041
Job Sheet 185682



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/31/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Large Fab-5		<i>[Signature]</i> 20/11/18
100	Large Fab	1 pcs	11/23/18	11/23/18	0.00	6.67	Large Fab 1		<i>[Signature]</i> 26/11/18
110	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC9		<i>[Signature]</i>
120	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC5		<i>[Signature]</i>
130	Powdercoat	1 pcs	11/23/18	11/23/18	0.00	0.40	Powdercoat4		<i>[Signature]</i> 28-11-27
135	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC3		<i>[Signature]</i> 18-11-27
140	HandFinish	1 pcs	11/23/18	11/23/18	0.00	0.80	HandFinish3		<i>[Signature]</i> 18-11-27
150	QC	1 pcs	11/23/18	11/23/18	0.00	0.00	QC3		<i>[Signature]</i> 18-11-27
160	Packaging	1 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-2		<i>[Signature]</i> 21 NOV 27 2018
170	QC21-SA	1 Ea	11/23/18	11/23/18	0.00	0.00	QC21		<i>[Signature]</i> 21 NOV 27 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138839 START: 9:00 TRAMP: 320 FINISH: 9:30

Job BOM

Part / Item	Component Name	Quantity	Operation	
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>2x 112 088</i>
D3914-1	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5123 503</i>
D3914-7	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5115 924</i>
D4016-3	Hinge Half, Lid	3 Ea (3 ea)	90-Start up Operation	<i>5121 277</i>
D4018-5	Rib	9 Ea (9 ea)	90-Start up Operation	<i>5115 926</i>
D4020-5	Mesh (350 Basket Long, Lid)	1 Ea (1 ea)	90-Start up Operation	<i>5113 739</i>
D4021-3	Data Plate	1 Ea (1 ea)	90-Start up Operation	<i>5114 584</i>
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 Ea (2 ea)	90-Start up Operation	<i>5123 306</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

90-Start up Operation

D2581	2	42	0
D3914-1	2	2	0
D3914-7	2	4	0
D4016-3	3	219	0
D4018-5	9	24	0
D4020-5	1	4	0
D4021-3	1	22	0
D4035-043	2	2	0

Part Specifications

Specifications could not be found.

Plex 10/31/18 11:39 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐	AGAINST DEPARTMENT/PROCESS			
		Skid-tube Machining ☐ Turn Forming ☐ Large Flat ☐ QTY Effective : _____	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐	Engineering Quality ☐ Other ☐
					MRB (QSI042) Approval
Disposition					Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval

FAULT CATEGORY			
☐	Power Loss/Surge	☐	Positioned Wrong
☐	Folio/Program	☐	Outside Dimensions
☐	Grain	☐	Over/Under tolerance
☐	Weld	☐	Part Incorrect
☐	Wrong Stock Pulled	☐	Part Lost/Missing
☐	Out of Sequence	☐	Part Moved
☐	Off-set	☐	Drawing
☐	Mislabeled	☐	Finish
☐	Fit/Function	☐	Misread
☐	Misaligned/off center	☐	Turning Sequence

☐	Centre Not Concentric	☐	BOM/Route
☐	Cracks	☐	Broken/Damage/Defect
☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified
☐	Cuffs	☐	Contamination
☐	Crushing	☐	Countersink
☐	Heat Treat	☐	Cut Too Short
☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear
☐	Marks/Chatter	☐	Drill Holes

☐	Offset/Setup	☐	OTHER :
☐	Supplier	☐	
☐	Training	☐	
☐	Use for Testing	☐	
☐	Poor Information	☐	
☐	Rushing	☐	
☐	Product Improvement	☐	
☐	Process Improvement	☐	
☐	Manufacturing Process	☐	
☐	Past Due	☐	

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Container No: S129656



Part: D3914 - 041

Job No: 185682

Serial No/Batch: S129656

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/20/18